



Dart Aerospace Ltd.
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Canada

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5031348

D3914-041
Job Sheet 168148



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 12/20/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/19/17	12/19/17	0.00	0.00	Start Up Large Fab-2		1/11/2018
100	Large Fab	1 pcs	12/19/17	12/19/17	0.00	6.67	Large Fab 1		1/11/18
110	QC	1 pcs	12/19/17	12/19/17	0.00	0.00	QC9		PD 18-01-17
120	QC	1 pcs	12/19/17	12/19/17	0.00	0.00	QC5		PD 18-01-17
130	Powdercoat	1 pcs	12/19/17	12/19/17	0.00	0.40	Powdercoat4		BR 18-01-17
135	QC	1 pcs	12/19/17	12/19/17	0.00	0.00	QC3		PD 18-01-18
140	HandFinish	1 pcs	12/20/17	12/20/17	0.00	0.80	HandFinish3		1/18-01-18
150	QC	1 pcs	12/20/17	12/20/17	0.00	0.00	QC3		BR 18-01-18
160	Packaging	1 pcs	12/20/17	12/20/17	0.00	0.00	Packaging3		1/18-01-17
170	QC21-SA	1 Ea	12/20/17	12/20/17	0.00	0.00	QC21		1/18-01-17

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 135418. START: 3:15 OVT: 3:00 FINISH: 3:45.

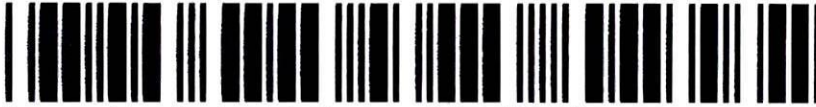
Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581	2	30	0	0
	D3914-1	2	4	0	0
	D3914-7	2	16	0	0
	D4016-3	3	31	0	0
	D4018-5	9	18	0	0
	D4020-5	1	0	0	0
	D4021-3	1	4	0	0
	D4035-043	2	6	0	0
	D2728-3	1	0	0	0
	D2728-3	1	0	0	0
140-HandFinish					

DART
AEROSPACE
S031348

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Long Basket Lid Assembly (350)

PART NO: D3914-041

Original Serial #: S031348

Revision:

Operation: Large Fab

Change No:

Mfg Date: 01/11/18

Job No: 168148